



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-2BL
Job Sheet 167806



Plot
(5)

Part No: D2933-2BL

Job Qty: 10 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/22/17	11/22/17	0.00	0.00	Start Up Machining		SBL 17/11/25
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.61	12.94	HAAS 1		SBL 17/11/27
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	12.92	Mill Conv 1		SBL 17/11/27
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		SBL 17/11/27
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		SBL 17-12-04
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	1.03	HandFinish1		2017-12-12 25
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	0.98	Spray Paint Outsourced		11 JAN 17 2018
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		PD/ 11 JAN 17 2018
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		ST 380 13 FEB 9-89/8/01/17
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		13 FEB 9-89

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484***

P10: 38646

DEC 13 1917
9-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:21 AM dart.Michaud-Febrille.Victoria

DQA: _____

Date: _____

QA Closed: _____

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order

DISPOSITION

PROCESS

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

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 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
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Mfg Date: 11/25/17
 Job No: 167806

Mfg Date: 11/25/17
 Job No: 167806

Water Jet	Engineering
Eng. Coord.	Quality
Packaging	Other
Supplier	

MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

DART
 AEROSPACE
S013864

Saddle RH In, 206

PART NO: D2933-2BL
Revision:
Operation: Outsource
Change No:

DART
 AEROSPACE
S013864

Saddle RH In, 206

PART NO: D2933-2BL
Revision:
Operation: Start up Operation
Change No:

Positioned Wrong	
Outside Dimensions	
Over/Under tolerance	
Part Incorrect	
Part Lost/Missing	
Part Moved	
Drawing	
Finish	
Misread	
Turning Sequence	

Fit/Function
Misaligned/off center

Drill Holes

Marks/Chatter

Process Improvement
Manufacturing Process

Past Due

OTHER :

Substation
Past Expiry Date
Misidentified

DART AEROSPACE LTD	Work Order: 167806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.121	SCRAP	.121	SBL	17/11/26
B	0.100	0.140		.123	.122		.122		
C	0.100	0.140		.120	.115		.118		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		.240	.250		.250		
F	1.245	1.255		.250	.250		.250		
G	2.495	2.505		2.500	2.500		2.500		
H	0.510	0.515		.515	.514		.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312		.312		
M	0.235	0.240		.237	.238		.238		
N	0.100	0.140		.120	.120	.120	.119		
O	0.540	0.560	.392	.550	.550		.550		
P	0.490	0.510		.500	.500		.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.251	.252		.252		
T	0.100	0.180		.145	.132		.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316		.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.575		1.575		
Z	0.178	0.198		.188	.188		.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL
Date: 27/11/26

Audited by: A.F.
Date: 17-12-04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 167 806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				# 5	# 6	# 7	# 8		
A	0.100	0.140		.120	.120	.119	.121	SBL	17/11/27
B	0.100	0.140		.121	.122	.119	.121		
C	0.100	0.140		.115	.115	.114	.113		
D	0.210	0.230		.221	.121	.221	.221		
E	1.245	1.255		.250	.250	.250	.250		
F	1.245	1.255		.250	.250	.250	.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		.238	.237	.239	.238		
N	0.100	0.140		.121	.121	.120	.120		
O	0.540	0.560		.550	.550	.548	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.251	.252	.248	.252		
T	0.100	0.180		.138	.140	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.585	1.585	1.565	1.585		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL
Date: 17/11/27

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 167806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	* #11	#12		
A	0.100	0.140		.120	.120	.120			
B	0.100	0.140		.122	.121	.121			
C	0.100	0.140		.113	.113	.112			
D	0.210	0.230		.221	.221	.221			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.513	.514	.513			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.257	.257	.257			
L	0.312	0.317		.312	.312	.312			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.120	.120	.120			
O	0.540	0.560		.560	.550	.548			
P	0.490	0.510		.500	.500	.500			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.495	2.495	2.495			
S	0.240	0.270		.251	.252	.251			
T	0.100	0.180		.140	.140	.137			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321		.316	.316	.316			
X	1.125	1.145		1.135	1.135	1.135			
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.585			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: BBL
Date: 17/11/27

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

* morceau pour remplacer la piece #3 qui est scrap.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646
PO Date: 12/14/17
Due Date: 12/15/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PAR16- 484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484***	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038646

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE *** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY *** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484 *** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484 *** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/17/18 10:04 AM dart.baker.diane